

# Work Order ID 84801

**\*84801\***

Page 1

May-23-12 11:31:09 AM

Item ID: D206-559-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw

Start Date: 23/05/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/23

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9527	rev A
IIN-D206-559	rev L

100 0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPPD206-559-011 CHG007

*5/12/03/163*

*for CL 12-7-3*

160 0.00

Pick Kit

**\*160\***

Packaging

Memo

0.00

Packaging

*5x*

*SP 12-7-3*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84801

May-23-12 11:31:09 AM

**\*84801\***

Page 2

Item ID: D206-559-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw

Start Date: 23/05/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC4- 100% Inspect kits for completeness	0.00							
<b>*170*</b>									
QC	Memo	0.00		8/26/03		(x5)			
Quality Control									
180		0.00							
<b>*180*</b>	Packaging								
Packaging	Memo	0.00				5x			50
Packaging	Identify and pack for shipping as per PPPD206-559-011								12-7-3
	Location: <u>11</u> <u>Rev C</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							12/7/5
Quality Control									

mf  
12-07-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-23-12 11:31:13 AM

Page 1

Work Order ID: 84801

\*84801\*

Parent Item: D206-559-011

\*D206-559-011\*

Parent Item Name: Bearpaw

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 5.00

Required Qty: 5.00

## Comments:

IPP Rev:C04.02.17Blank size changedKJ/JLM

IPP Rev:D 07-01-02 Was K10007 JLM

IPP Rev:E 08-05-05 up a chg DD verified by:EC

IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified

By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A

Purchased

No

160

Each

604.0000

8

40

\*\*

\*AN4-17A\*

Bolt

### Location

### Loc Qty

### Loc Code

ST358

300

116704

0

121541

300

ST359

304

112314

0

121011

200

121068

104

AN4-20A

Purchased

No

160

Each

551.0000

8

40

\*\*

\*AN4-20A\*

Bolt

### Location

### Loc Qty

### Loc Code

GA

50

116419

50

ST359

501

117514

51

121060

150

121541

300

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-23-12 11:31:13 AM

Page 2

Work Order ID: 84801

\*84801\*

Parent Item: D206-559-011

\*D206-559-011\*

Parent Item Name: Bearpaw

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 5.00

Required Qty: 5.00

AN960JD416

NAS1149D0463J

Purchased

No

160

Each

30.0000

16

80

\*AN960JD416\*

Washer

\*\*

m121912 sp. L

## Location

## Loc Qty

## Loc Code

ST351

30

116289

10

119097

20

D2182B

Manufactured

No

160

f

138.5952

1.666

8.33

\*D2182B\*

Rubber Cushion

\*\*

sp

## Location

## Loc Qty

## Loc Code

ST410

138.59517

63413

1.6

66063

41.61817

73932

95.377

(D2182B050) Cut (4) at 5.00" as per dwg \*\*\*per

kit\*\*\*

D2274

Manufactured

No

160

Each

376.0000

8

40

\*D2274\*

Radius Block

\*\*

B84199 sp

## Location

## Loc Qty

## Loc Code

ST007

376

78233

2

81958

164

83258

210

D2435

Manufactured

No

160

Each

0.0000

10

\*D2435\*

Bearpaw, 206

\*\*

B84802 sp  
12-7-3.

May-23-12 11:31:13 AM

Shop Packet Print

Page 2

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

May-23-12 11:31:13 AM

Page 3

Work Order ID: 84801

\*84801\*

Parent Item: D206-559-011

\*D206-559-011\*

Parent Item Name: Bearpaw

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 5.00

Required Qty: 5.00

D2438

Manufactured No

160

Each

89.0000



20

\*\*

SP

h

\*D2438\*  
Clamp

## Location

## Loc Qty

## Loc Code

ST456

89

77038

6

83265

33

83266

50

~~770~~

20x

D2529

Manufactured No

160

Each

765.0000



40

\*\*

SP

h

\*D2529\*  
Washer

## Location

## Loc Qty

## Loc Code

ST010

765

79485

18

81873

247

84435

500

40x

MS21042L4

Purchased No

160

Each

4,414.000



40

\*\*

SP 12-7-3.C

\*MS21042L4\*  
Nut

## Location

## Loc Qty

## Loc Code

ST300

4414

119075

125

121011

1032

121444

2957

121652

300

40x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-23-12 11:31:14 AM

Page 4

Work Order ID: 84801

\*84801\*

Parent Item: D206-559-011

\*D206-559-011\*

Parent Item Name: Bearpaw

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 5.00

Required Qty: 5.00

QS200-M44S

Purchased

No

160



Each

41.0000

10

\*\*

SP 12-7-3

  QS200-M44S\*

Location

Loc Qty

Loc Code

ST455

41

115589

1

119436

15

121068

25

10x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-559 REV. K OR EARLIER AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-559 REV. 2 OR EARLIER  
REF. TCCA STC: SH92-17  
REF. FAA STC: SH1031NE

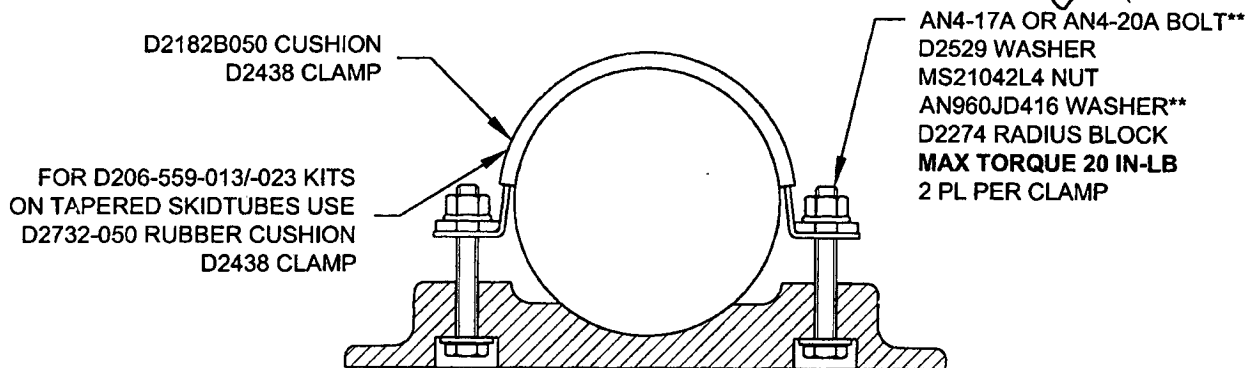
## PURPOSE:

For D206-559-011/-013/-021/-023/-031/-033 bearpaw kits, the AN4 bolts specified were for installation with the aft skidtube wearshoe removed. Bolt lengths are increased to accommodate installation with the skidtube wearshoe installed, which is more practical.

## CHANGE:

The parts list is updated as shown on sheet 2 of this service instruction, for bearpaw kits: D206-559-011 at CHG 007, D206-669-013 at CHG 006, D206-559-021 at CHG 008, D206-559-023 at CHG 007, D206-559-031 at CHG 002, and D206-559-033 at CHG 002.

Figure 4 of D206-559 and Figure 32-3 of ICA-D206-559 are amended as follows:



\*\*USE AN4-17A BOLTS WITH AN AN960JD416 (OR NAS1149D0463J) WASHER IF INSTALLING BEARPAW ON 3.0" DIA. TUBE OR SMALLER. USE AN4-20A BOLTS WITH TWO AN960JD416 WASHERS IF INSTALLING BEARPAW ON TUBE LARGER THAN 3.0" DIAMETER (DART TUBE). ADDITIONAL AN960JD416 WASHERS MAY BE ADDED UNDER NUT TO ENSURE 2-4 THREADS IN SAFETY. IT IS ALSO ACCEPTABLE TO USE LONGER/SHORTER AN4 BOLTS IF REQUIRED TO ENSURE BEARPAW IS HELD SECURELY.

**FIGURE 4: TYPICAL CLAMPING DETAIL (D206-559)**  
**FIGURE 32-3: TYPICAL CLAMPING DETAIL (ICA-D206-559)**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)  
DATE: 10.06.30  
CERT. NO.: SH92-17  
ISSUE NO.: 7

A	NEW ISSUE	CP	10.06.30
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BOLT CHANGE	NTS
DATE	10.06.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST (D206-559 REV. K)  
32.7 PARTS LIST (ICA-D205-559 REV. 2)






Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						2	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT (WAS AN4-15A)
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER (OR NAS1149D0463J)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER (OR AN960JD416)
2		2					QS200M44S	CLAMP

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 10.06.30  
CERT. NO.: SH92-17  
ISSUE NO.: 7

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT CHANGE	NTS
DATE	10.06.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

10878

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



## 5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
/ 4	6	4	6				D2182B050	RUBBER CUSHION
/ 8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
/ 4	6	4	6				D2438	CLAMP
/ 8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
/ 8	12	8	12	8	12		AN4-17A	BOLT
/ 8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
/ 8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP